

Work Order ID 53221

October 27, 2009 10:20:58 AM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID: C

Stop



Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/10/27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2438	Rev C

100



PURCHASING

Purchasing

Memo

0.00

CL 09/10/27

100

Purchasing

Issue P/O: 10047 Laser cut as per Dwg D2438 Material release note is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

PC 9/11/09

100

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

(6.786" center to center)

=> Saluto

cocute

FL42

QSP019

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Sign & initial all entries

Work Order ID 53221

October 27, 2009 10:20:58 AM



Page 2

Item ID: D2438

Accept



Setup

Start



Revision ID: C

Stop



Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130

**Operation
Description**

Small Fab

Small Fab

Small Fab Memo Tumble & Deburr any rough edges

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

B9-11-23

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2780211/23

coate

(x02)

f

150



Packaging

Packaging

Identify as per dwg & Stock Location: 456

0.00

Memo

0.00

9/11/24

(102) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53221

Page 3

October 27, 2009 10:20:58 AM

Item ID: D2438

Accept



Setup Start



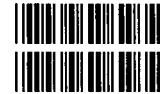
Revision ID: C

Stop



Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

09/11/25 JF

Pd 09-11-24
(100)

Picklist Print

October 27, 2009 10:20:57 AM

Page 1

Work Order ID: 53221



Parent Item: D2438RevC



Parent Item Name: Clamp

Start Date: 10/27/09

Required Date: 11/20/09

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2438BRevC 	Clamp	Purchased	No			110	Each	0.0000	100.0000 		10/27/09 	(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

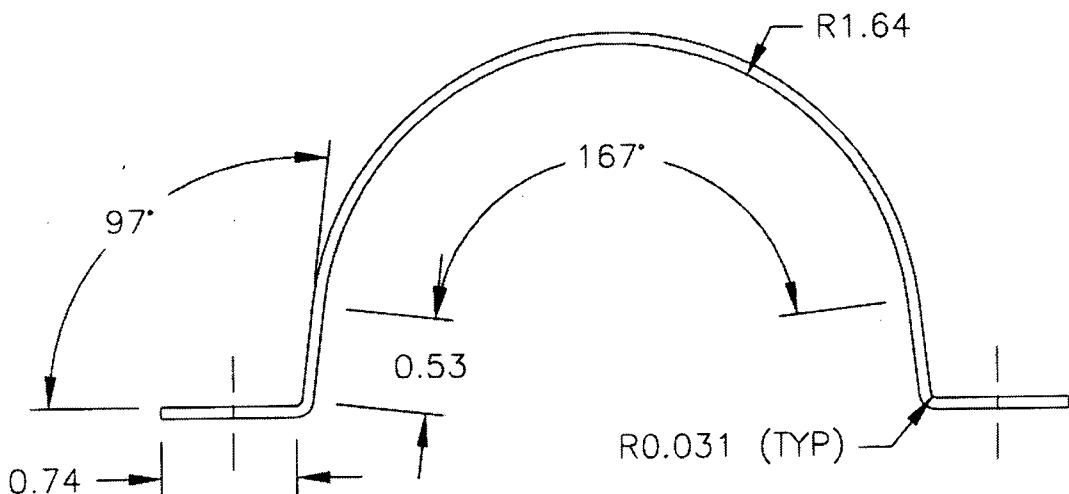


COPY ISSUED
FD

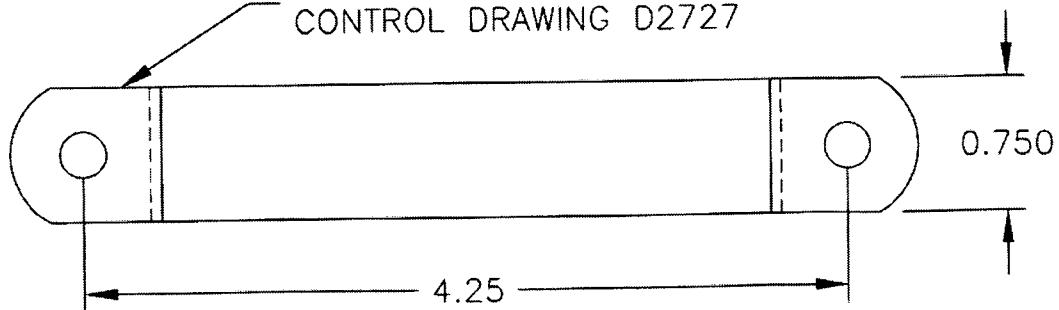
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BW</i>	APPROVED <i>AS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1

RELEASED
98.06.17 KE

A	96.01.24	NEW ISSUE
B	96.05.13	CHANGE LENGTH
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY



PUNCH ENDS PER SPEC
CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53221
(709/10/2)

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

*10006.06
(P)*



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2009/11/18	0428248

VIENNU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO..	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0206784	PO10647	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
100	D2438B	CLAMP CUT&FORMED CERTIFICATE OF CONFORMANCE REQ	

MFG. JOB # J0206784-01 QTY 100

8

S
11/20

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 22 OUR JOB NO J0206784 SHIPPING MEMO 0428248

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	<u>100 PCS</u>	<u>PO10647</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>S.S.T 304</u>		<u>TW METALS / ALLEGHENY LUDLUM</u>		<u>828977</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0206784-01</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 18 NOVEMBER 2009

G.F.I. Q.C. REP.

DP12-001 REV 0 Bombardier Certificate of Compliance
TW Metals District Procedure

Revision 0

Revision Date 04-03-00

Superseding Initial

Page 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law Title 18 chapter 47

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard

CUSTOMER NAME GFIPURCHASE ORDER No 0075846ITEM No 0001 SHIPPER INVOICE NO 03251327MATERIAL 304-5/5 Sheet SPECIFICATION AMS 2248FMANUFACTURING MILL ATI Allegheny LudlumSIZE .0625 HEAT / LOT No 1828977PART NO TSD6348X964A QUANTITY 2EA.TEST DEPARTMENT CLERK Amy Davis

AUTHORITY

Joe Schab
Director of Quality Assurance

[Handwritten signature]

**NOTICE OF SHIPMENT
PACKING LIST**



Allegheny
Lithium

CERTIFICATE OF TEST

CH 10-150

DATA CODE	ACCEPTING BILL	INQUIRY NO.	PROJ. CODE	BILL ORDER NUMBER	DATE SHIPPED
04/02/09 110977	VANDERGRIFT, PA. 623467 DO PR DOVY DOVY CONTRACT	13020102060000 3D-049-021 MAIL SHIPPING LOCATION	11124 11124 PA	06/22/09 OFFICE	
REBATE UNDER 82037-4 [26]					
PRIME SEC. DSO DSO 584					

GRADE AND SPECIFICATIONS

GRADE AND SPECIFICATIONS CARRIER - CLAY TRANSPORT, INC.
 ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED 2B FIN 3 RDGB (UPM 304L/304/302 LCS) (AMS 2248P) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A1) (ASTM-A-666-03) (S-400 DTSD 10/31/07) (ASTM-A-240-08A) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (10/22/08 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (PMA 300 REV BH) (F-14, F-17, F-22, F-23, F-MASTER)
 (CONTROLLED TO PMA LCS REQUIREMENTS)

AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUM'S KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

IC CODES SHOWN UNDER METAL SOURCE CAN BE INTERPRETED AS FOLLOWS:
1. - MATERIAL MINTED AND BOLTED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998.
SECTION 252.225-7014
2. - FOREIGN MINTED AND BOLTED IN THE UNITED STATES

TW METALS
T 149211688
E JUN 29 2009
S
T
ACCEPTED BY *Lee*

06/22/09 09:48:07

PAGE 02 - CONTINUED ON PAGE 03

CONFIDENTIAL. Please Note: The information contained herein is
pertinent to Bank Credit Underwriting, nothing contained herein, or any part thereof,
is to be reproduced by the user or disclosed outside the pertinent office. If any information
contained herein is disclosed, please advise the Bank Credit Underwriter.
If any information
is reproduced, please advise the Bank Credit Underwriter.

Important Safety Data Sheets for this product are available from your Honeywell Distributor. For an immediate price quote, call 724-229-6577. **CALCIUM: Protecting the respiratory tract, dust or smoke may cause lung disease. See Material Safety Data Sheets for further information.**

Les bases d'information-éducatif sur ce produit ont été formées à partir des documents suivants des années. Pour consulter des documents supplémentaires, veuillez visiter le site Web de l'OMS : www.who.int/tdis/policy/WHO_HR_2004_07.pdf. Assurez-vous que les informations nécessaires se trouvent dans le rapport, puis contactez les autorités compétentes ou les autorités de protection de la santé publique, des autorités de protection environnementale. Pour plus de renseignements sur ce document, veuillez contacter l'OMS.

Tracy McKEE
Director, Corrections Quality Assurance

NOTICE OF SHIPMENT/
PACKING LISTAllegheny Ludlum
Industry Technologies

CERTIFICATE OF TEST

AL0808300

OUT. ORG. NO. & DATE	DUE. CODE	SHIPPER NO.	PRODUCT CODE	SELL. DOCUMENT NO.	DATE SHIPPED
01014169 FOLIO DISTRIBUTION 8841 8851 8861	04/02/09 110977	VANDENGRIFT, PA. 023467 ASPEX CALS DATE ONLY 82037-4 26 PRIME SEC. DSO DSO 584	13020102060000 30-049-021 WHL SUPPLY LOCATION PA 657053	06/22/09 WHL PA	

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED, 2B FIN 3 EDGE (UHM 304L/304/302 LCS) (AMS 2248F) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-08A) (S-1080 DATED 1/2/08) (ASME-SA-240-07) (10/22/08 EXCEPT UHM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UHM-QRS-001) (PMA 300 REV BH) (P-14, P-17, P-22, P-MASTER)
(CONTROLLED TO PMA LCS REQUIREMENTS)

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:
C, S BY COMBUSTION/INFRARED
N, O, H BY INERT FUSION/ THERMAL CONDUCTIVITY
Mn, P, Si, Cr, Ni, Mo, Cu, Nb, Co, V BY WDXRF
B BY OES
Al AND Ti (>=0.10%) BY WDXRF, OTHERWISE BY OES
Pb, Bi, Ag BY GPAA

FINAL MECHANICAL TESTING PERFORMED BY WESTMORELAND MECHANICAL TESTING & RESEARCH, YOUNGSTOWN, PA (T7869) GEAB S460 AND ISO/IEC 17025 APPROVED FACILITY.

MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014

Moor Metals Inc.
Moor # M-14541
Cust PO # 1044211688
Pt # R5913
Alloy/Spec 304 ASTM A-240
Quantity & Size 744 ft. - .0625 X 48.00 X 120.00
Mill Allegheny Ludlum
Lot # /Heat # 628977
6/28/09
Authorized Signature Tony Meek

TEST >>>>>
>>>>>1009 14:16
R DEPT.

The above is a copy of data on file for this order for your use in your internal quality control and performance assessment. It is not to be distributed outside your organization without prior written permission from Allegheny Ludlum.

Tony Meek
Director, Corporate Quality Assurance

S 07/11/20

TW METALS	
T	M49211688
E	JUN 29 2009
S	REPORT
T	CERT
ACCEPTED BY	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10647

Purchase Order Date 10/27/09
PO Print Date 10/27/09

Page Number 1 of 1

Order From : VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

FAXED
10/27/09

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2438B C	Clamp	11/20/09 Yes	100.00 Each	Purolator ground	\$10.0000	\$1,000.00

Special Inst: AS PER DWG D2438 REV.C
B53221
FORMED & BEND AS PER DWG

PO Total: \$1,000.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 10/27/09